

Work Order ID 109737

109737

Page 1

November-27-13 12:44:44 PM

Item ID: D350-636-012

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 11/27/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 11/27/13 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: MLS Date: 13-11-27 Tooling:

Date:

Run Start *NR1*

QC: Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
----------	--------------

D2750-042	G
-----------	---

D3492	C
-------	---

100

100

DOCUMENT CONTROL

0.00

0.00

DC

Memo

Document Control

record fwd angle:

89.1°

Photocopy blue file and type labels per PPP D350-636-012 CHG 007

13/12/02

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Item ID: D350-636-012

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 11/27/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 11/27/13 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00

110

Skidtubes

0.00

Skidtubes

Skidtubes

Memo

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail K)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.
SECOND SIDE

8-Open up holes for Detail "K" to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail L to 0.500" (8 holes per side)

9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10-Open up holes of Detail J to 0.297" (total of 2 holes per side)

13/12/02

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Item ID: D350-636-012 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.
 Start Date: 11/27/13 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 11/27/13 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left
 from bending as per QSI 004

A/R Aluminum Rod batch: *m126325* *> BEB/12/02*

12-Grind welds flush as per Dwg D2750

120
 120
 QC
 Quality Control

QC10- Inspect visual per QSI004- ground welds 0.00
 Memo 0.00

DAS
 27
 9-89
B/12/03

1

130
 130
 QC
 Quality Control

QC5- Inspect part completeness to step on W/O 0.00
 Memo 0.00

DAS
 27
 9-89
B/12/03

1

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November 27-13 12:44:44 PM

Item ID: D350-636-012 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.
 Start Date: 11/27/13 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 11/27/13 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140	HandFinish	0.00							
	Hand Finishing								
150	QC7-Inspect Chemical Conversion Coat	0.00							
150	QC	0.00							
	Quality Control								

- OK 13/12/03

1 B 13/12/03

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Item ID: D350-636-012 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.
 Start Date: 11/27/13 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 11/27/13 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Skidtubes	0.00							
160									
Skidtubes	Memo	0.00							
Skidtubes	1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.								
	2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.								
	3-Open float holes to .500" (4 per Side)								
	4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)								
	5-Deburr and blow out all chips from inside of tube								
	6-Prepare tube for welding, remove alodine as required.								
	7-Bond web D2739 in place as per QSI 015 A/R Sikaflex-291 batch: 127317/14/08/16 exp. date: 14/08/16								
	8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9) A/R Aluminum Rod batch: m126325								
	9- At section AP-AP drill out x-bolt spacer to 0.404"								
	10-Grind welds flush as per Dwg D2750								
	11-Spot face ground handling holes section (total of 4 places per side) as per								

- DL 13/12/03

> 8413/12/05

- DL 13/12/07

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Item ID: D350-636-012

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Stop *NS2*

Start Date: 11/27/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 11/27/13 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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dwg D2750

12-Deburr holes

> - DC 13/12/04

170

QC10- Inspect visual per QSI004- ground welds 0.00

170

QC

Memo

0.00

Quality Control

PTO

180

QC5- Inspect part completeness to step on W/O 0.00

180

QC

Memo

0.00

Quality Control

VERIFY C'BOARD IS GOOD

N/A

PTO

DQA:

Date: 14/01/02



QA Closed:

Date: 13/12/20

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: 109737	DISPOSITION Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS			
Part No. 0350-636-012		Skid-tube <input checked="" type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. 13-3371		Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design				Found at inspection that		SCRAP + Destroy			
Doc/Data				Aft sample holes do		Rez Eng not	DAS 27 9-89	DAS 27 9-89	S
Equip/Tooling				not align with Blade		Acceptable to perform	13/12/17	13/12/17	13/12/17
Handling/Pre				fitting		Rework to aft end			
Material				RC Drilling to match					
Operator				Front end too tight					
Offset/Setup				tooling not adequate					
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input checked="" type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input checked="" type="checkbox"/> </div> </div>
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre	13-12-5	180	1	Remove c-bore is Good" only applicable to delay Models		Scrap No replace			
Material									
Operator									
Offset/Setup									
Process									
Supplier				Part found during inspect that the saddle do not fit as per drawing					
Training									
Transport									
Unapproved				QC web more					

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Item ID: D350-636-012

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Stop *NS2*

Start Date: 11/27/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 11/27/13 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Pressure Wash per QSI005 4.3	0.00							
190									
HandFinish	Memo	0.00							
Hand Finishing	Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.								
200		0.00							
200									
SprayPaint	Memo	0.00							
Spray Painting	1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: _____ 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: _____								
210	QC14- Inspect Spray Paint	0.00							
210									
QC	Memo	0.00							
Quality Control	Inspect for foreign object per QSI 024								

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Page 8

230

230

HandFinish

Hand Finishing

HandFinishing

Memo

1-Install inserts as per dwg D2750

2-Inspect for Foreign Objects

3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750
SIKA FLEX 241

BATCH:

EXP DATE: _____

4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube
A/R 55-o'ring lube batch:

5-Coat all exposed fasteners with "LPS Procyon" batch:

240

QC5- Inspect part completeness to step on W/O	0.00
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240

QC

Quality Control

Memo

Work Order ID 109737

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Item ID: D350-636-012

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 11/27/13 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 11/27/13 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
250									
Packaging	Memo	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
260									
QC	Memo	0.00							
Quality Control									
270		0.00							
270	Packaging								
Packaging	Memo	0.00							
Packaging	Package as per PPP D350-636-012								

Work Order ID 109737

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Item ID: D350-636-012

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 11/27/13 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 11/27/13 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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280

QC21- Final Inspection - Work Order Release

0.00

280

QC

Memo

0.00

Quality Control

MB-12-18

Picklist Print

Page 1

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Work Order ID: 109737

109737

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 11/27/13

Required Date: 11/27/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:102.09.25Rearranged procedure stepsKJ
 IPP Rev:J 06-03-29 As per Rev D EC IPP REV:K
 AS PER REV F JLM 13-08-22 VERIFIED BY:DD
 IPP Rev:K 06-07.13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
 IPP Rev:M 08-04-22 update steps 4,13 DD verified by:EC
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec IPP Rev:O
 10.06.22 revise seq110 DD verf:EC IPP Rev:P 10.10.01 as
 per IIN revH DD verf:EC IPP REV:Q 13.08.27 PER ECN13-
 594 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2600-3-BENT		Manufactured	No			110	Each	22.0000	1	1			
D2600-3-BENT									**	1		13/12/02	
Extrusion Bent													

Location	Loc Qty	Loc Code
LG002	22	
105198	1	
107404	4	
66875	7	
73253	1	
75021	1	
75022	1	
75023	1	
81330	4	
83305	1	
97615	1	

Picklist Print

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Work Order ID: 109737

109737

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 11/27/13

Required Date: 11/27/13

Start Qty: 1.00

Required Qty: 1.00

D2744

Manufactured No

110

Each

62.0000

1

1

D2744

**

DE 13/12/03

Cap

Location

Loc Qty

Loc Code

LG001

62

100398

28

62715

1

97543

33

Manufactured No

160

Each

4.0000

1

1

D2739

D2739

**

DE 13/12/03

350 L Beam

Location

Loc Qty

Loc Code

LG002

4

106933

1

97319

1

97618

2

①

Picklist Print

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 11/27/13

Required Date: 11/27/13

Start Qty: 1.00

Required Qty: 1.00

D2743

Manufactured No

160

Each

313.0000

8

8

D2743

Crossbolt Spacer

**

BE 13/12/04

Location

Loc Qty

Loc Code

LG001

313

101033

2

106245

12

106876

2

107359

124

107907

63

67766

4

68251

3

73403

64

74445

1

79517

2

81965

23

83262

2

85459

4

88504

2

95148

2

95901

2

97584

1

D3490-3

Manufactured No

160

Each

112.0000

4

4

D3490-3

Cross Bolt Spacer

**

BE 13/12/04

Location

Loc Qty

Loc Code

LG001

112

103883

14

105603

31

107913

63

92443

1

95223

3

Picklist Print

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Work Order ID: 109737

109737

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 11/27/13

Required Date: 11/27/13

Start Qty: 1.00

Required Qty: 1.00

D3490-1

Manufactured No

160

Each

114.0000

4

4

D3490-1

Cross Bolt Spacer

**

BE 13/2/04

Location

Loc Qty

Loc Code

LG001

114

100560

2

101117

2

103881

2

105602

3

107419

87

62450

2

74875

4

77042

3

81976

2

94805

2

95977

1

97621

2

99074

2

D3631-1

Manufactured No

230

Each

201.0000

8

8

D3631-1

Washer

**

Location

Loc Qty

Loc Code

FP001

186

106188

4

106837

60

107324

100

81874

2

83588

18

91606

1

94702

1

FP002

15

68062

2

75548

13

Picklist Print

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Work Order ID: 109737

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 11/27/13

Required Date: 11/27/13

Start Qty: 1.00

Required Qty: 1.00

D3791-1

Manufactured No

230

Each

13.0000

1

1

D3791-1

Wearpad

Location

Loc Qty

Loc Code

FP002

13

106144

10

62239

2

83392

1

D3793-3

Manufactured No

230

Each

19.0000

1

1

D3793-3

Wearplate Aft

Location

Loc Qty

Loc Code

FP001

13

104212

12

92487

1

FP002

6

106663

6

MS21043-6

Purchased No

230

Each

328.0000

4

4

MS21043-6

NUT

Location

Loc Qty

Loc Code

FG

20

103693

20

ST315

250

117887

2

120308

2

m127255

246

ST506

58

124485

58

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Shop Packet Print

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Picklist Print

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Work Order ID: 109737

109737

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 11/27/13

Required Date: 11/27/13

Start Qty: 1.00

Required Qty: 1.00

D3794-1

Manufactured No

230

Each

25.0000

1

1

D3794-1

Gasket Fwd

Location

Loc Qty

Loc Code

FP001

25

101046

1

104620

1

108497

7

109207

12

87631

2

92426

1

95913

1

NAS1611-010

Purchased

No

230

Each

259.0000

8

8

NAS1611-010

O-RING

Location

Loc Qty

Loc Code

FP001

259

110915

14

117460

8

118077

1

118612

3

119438

7

121259

2

121584

2

121723

7

122151

8

123348

29

123352

4

124580

4

125484

14

m126988

156

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Work Order ID: 109737

109737

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 11/27/13

Required Date: 11/27/13

Start Qty: 1.00

Required Qty: 1.00

D2741 Manufactured No 250 Each 55.0000 1 1

D2741

Blade

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	11	
100664	6	
85480	1	
98323	4	
ST466	44	
104976	3	
107206	38	
71856	1	
85480	1	
98323	1	

NAS1515H3L Purchased No 230 Each 197.0000 4 4

***NAS1515H3I ***

Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	40	
102472	40	
ST297	157	
121556	45	
124542	112	

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Work Order ID: 109737

109737

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 11/27/13

Required Date: 11/27/13

Start Qty: 1.00

Required Qty: 1.00

NAS1611-013

Purchased

No

230

Each

214.0000

8

8

NAS1611-013

O-RING

Location

Loc Qty

Loc Code

FP001

214

116582

5

117291

2

117887

53

119623

36

121825

10

122993

3

124231

1

125445

104

AN3C6A

Purchased

No

230

Each

721.0000

4

4

AN3C6A

Bolt

Location

Loc Qty

Loc Code

FG

10

122416

10

FP001

30

122599

30

FP002

1

111982

1

ST350

17

122416

17

ST512

663

m125709

663

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Work Order ID: 109737

109737

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 11/27/13

Required Date: 11/27/13

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0832R

Purchased

No

230

Each

250.0000

1

1

NAS1149C0832R

Washer

Location

Loc Qty

Loc Code

ST292

250

122441

100

m125807

150

D3536-25

Manufactured

No

230

Each

36.0000

1

1

D3536-25

Gasket Center

Location

Loc Qty

Loc Code

FG

6

87053

2

95328

4

FP001

30

105965

2

109206

24

83900

1

89057

1

93696

1

95686

1

D3794-3

Manufactured

No

230

Each

27.0000

1

1

D3794-3

Gasket Aft

Location

Loc Qty

Loc Code

FP001

27

105529

6

108413

18

74530

2

92658

1

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Work Order ID: 109737

109737

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 11/27/13

Required Date: 11/27/13

Start Qty: 1.00

Required Qty: 1.00

AN3C5A Purchased No 230 Each 445.0000 34 34

AN3C5A

Bolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	5	
122800	5	
ST350	440	
m127290	440	

D3537-1 Manufactured No 230 Each 91.0000 3 3

D3537-1

Wearpad

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	18	
79833	8	
88562	10	
FP001	73	
100524	6	
107384	7	
108118	60	

D3535-25 Manufactured No 230 Each 24.0000 1 1

D3535-25

Wearplate Center

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	2	
95077	2	
FP002	22	
105549	7	
106128	11	
62233	1	
81357	1	
87385	1	
90061	1	

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Work Order ID: 109737

109737

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 11/27/13

Required Date: 11/27/13

Start Qty: 1.00

Required Qty: 1.00

D3492-3

Manufactured No

230

Each

267.0000

8

8

D3492-3

Plug

Location

Loc Qty

Loc Code

FP001

227

104853

102

106844

18

107331

89

81967

5

83099

3

85461

1

86865

2

95124

4

99012

3

FP002

40

107915

40

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Work Order ID: 109737

109737

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 11/27/13

Required Date: 11/27/13

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

230

Each

11,793.00

38

38

NAS1149C0332R

WASHER

Location

Loc Qty

Loc Code

FP001

254

123355

254

ST292

119

123248

18

123759

10

125268

91

st510

9730

m126319

4230

m127306

2500

m127410

3000

ST511

1564

125654

1564

ST517

126

124580

126

D3488-042

Manufactured

No

230

Each

16.0000

1

1

D3488-042

Blade Fitting RH

Location

Loc Qty

Loc Code

FP001

16

103879

5

106658

6

83417

1

98887

4

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Work Order ID: 109737

109737

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 11/27/13

Required Date: 11/27/13

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

Purchased

No

230

Each

1,117.000

38

38

AI S4-1032-225

Rivnut

Location

Loc Qty

Loc Code

FG

30

M127028

30

ST280

295

M125954

20

M127028

275

st555

792

M127092

792

D3492-1

Manufactured

No

230

Each

341.0000

8

8

D3492-1

Plug

Location

Loc Qty

Loc Code

FP001

341

100504

2

101063

3

104844

283

107914

24

69531

8

74444

2

76235

4

83098

7

88541

3

91466

2

97266

3

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Work Order ID: 109737

109737

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 11/27/13

Required Date: 11/27/13

Start Qty: 1.00

Required Qty: 1.00

D3793-1 Manufactured No 230 Each 20.0000 1 1

D3793-1

Wearplate Fwd

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	20	
100333	1	
105532	4	
109205	9	
82171	2	
87273	3	
92382	1	

AN8C35A Purchased No 230 Each 69.0000 1 1

AN8C35A

Bolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	5	
121275	5	
FP001	63	
115960	1	
121275	1	
m126293	31	
m127061	30	
st507	1	
124827	1	

Picklist Print

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Work Order ID: 109737

109737

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 11/27/13

Required Date: 11/27/13

Start Qty: 1.00

Required Qty: 1.00

MS21083C8	Purchased	No	230	Each	85.0000	1	1
-----------	-----------	----	-----	------	---------	---	---

MS21083C8

Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST319	82	
123900	3	
125484	1	
m126274	6	
m127255	72	
ST506	3	
124308	3	

D2745	Manufactured	No	230	Each	302.0000	8	8
-------	--------------	----	-----	------	----------	---	---

D2745

Bushing

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST017	302	
106847	120	
107336	124	
107908	58	

AN6C44A	Purchased	No	230	Each	122.0000	4	4
---------	-----------	----	-----	------	----------	---	---

AN6C44A

Bolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	2	
103964	2	
st503	120	
m127300	120	

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Work Order ID: 109737

109737

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 11/27/13

Required Date: 11/27/13

Start Qty: 1.00

Required Qty: 1.00

D3532-1	Manufactured	No	250	Each	38.0000	2	2
---------	--------------	----	-----	------	---------	---	---

D3532-1

Spacer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST054	38	
100519	38	

MS21083C8	Purchased	No	250	Each	85.0000	2	2
-----------	-----------	----	-----	------	---------	---	---

MS21083C8

Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST319	82	
123900	3	
125484	1	
m126274	6	
m127255	72	
ST506	3	
124308	3	

NAS1149D0863J	Purchased	No	250	Each	1,120.000	2	2
---------------	-----------	----	-----	------	-----------	---	---

NAS1149D0863.J

Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP001	4	
118078	4	
ST294	1116	
125268	600	
125484	216	
125635	300	

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Work Order ID: 109737

109737

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH Aerazur / Apical Cylindrical Compat.

Start Date: 11/27/13

Required Date: 11/27/13

Start Qty: 1.00

Required Qty: 1.00

D3493-1

Manufactured No

250

Each

114.0000

2

2

D3493-1

Washer

Location

Loc Qty

Loc Code

FG

10

97201

10

ST051

104

105613

44

107916

60

***ONLY INSTALL IF INSTALLING ON APICAL
FLOAT SYSTEM***

AN8C21A

Purchased

No

250

Each

75.0000

2

2

AN8C21A

Bolt

Location

Loc Qty

Loc Code

ST

2

123966

2

ST342

2

123966

2

ST505

71

m127061

71

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QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1			D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

109737 MJS
13-11-27

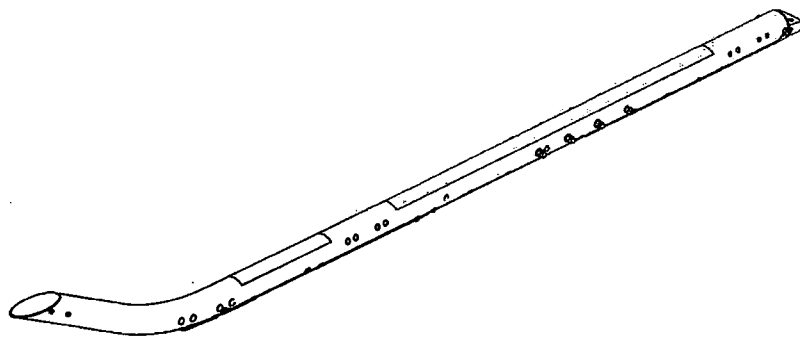
RELEASED
2013-08-13
ND

G	CORRECTED TOLERANCE ON Ø0.500 THRU HOLE: IS +0.010/-0.000, WAS +0.100/-0.000 (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5/-6/-7); UPDATED FINISH OPTIONS; INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3. REASON: PART 13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 06-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H3L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	MM		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.07.11		

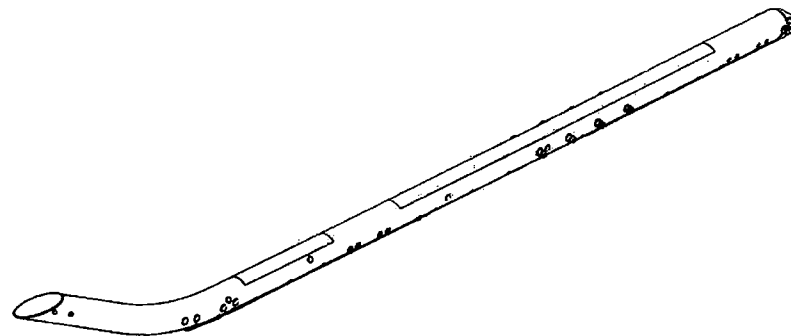
DART AEROSPACE USA, INC.
KENT, WA

DRAWING NO.
D2750
TITLE
350 SKIDTUBE ASSEMBLY
REV. G
SHEET 1 OF 11
SCALE
NTS

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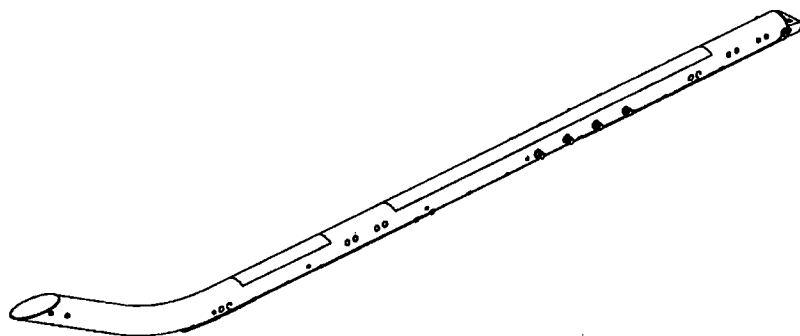
D2750-041 350 SKIDTUBE ASSEMBLY, LH



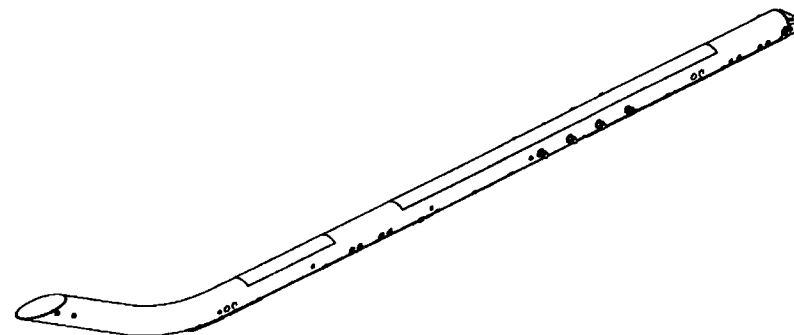
D2750-042 350 SKIDTUBE ASSEMBLY, RH

RELEASED
2013-08-13
MD

DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 2 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	<small>COPYRIGHT © 1999 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR REPRODUCED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



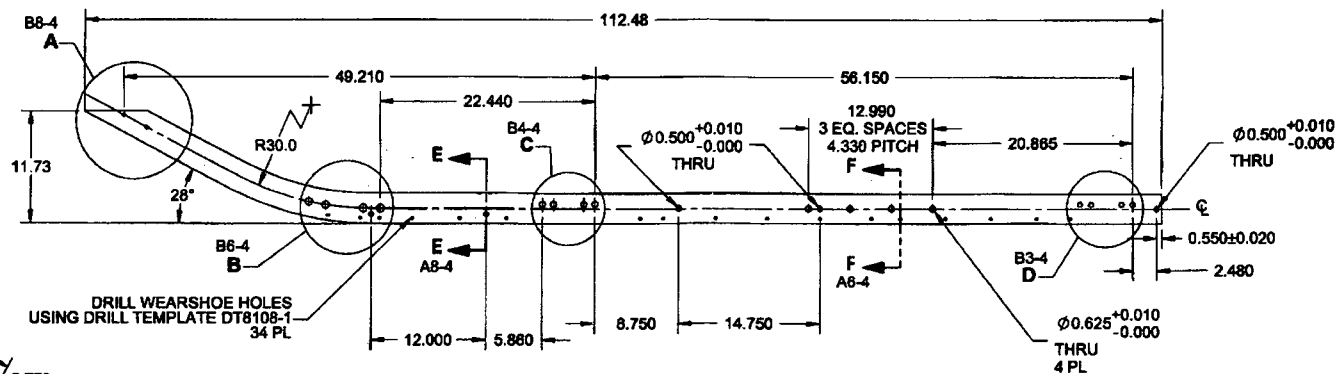
D2750-043 350 SKIDTUBE ASSEMBLY, LH



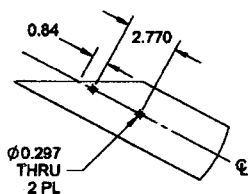
D2750-044 350 SKIDTUBE ASSEMBLY, RH

RELEASED
2013-08-13
MD

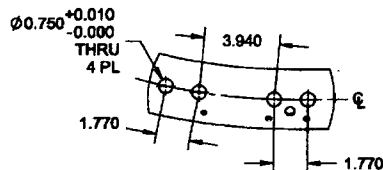
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DRAWN	<i>[Signature]</i>	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. G
MFG. APPR.	<i>[Signature]</i>	D2750	SHEET 3 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	<small>COPYRIGHT © 1999 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



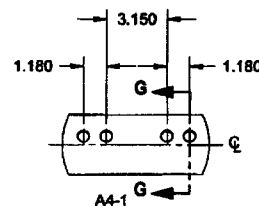
D2750-1 LH SKIDTUBE



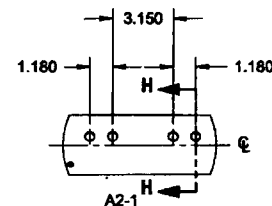
DETAIL A
SCALE 2X



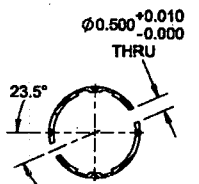
DETAIL B
SCALE 2X



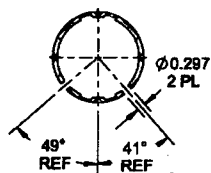
DETAIL C
SCALE 2X



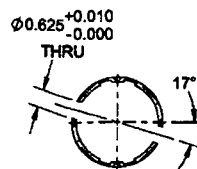
DETAIL D
SCALE 2X



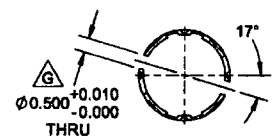
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



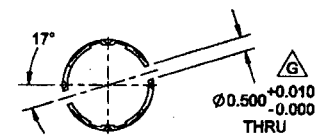
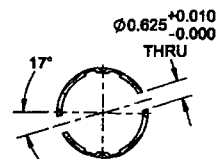
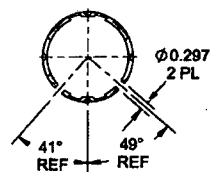
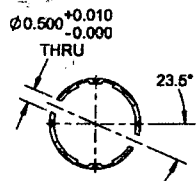
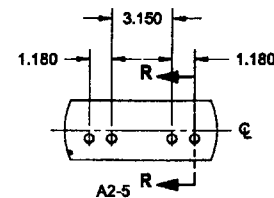
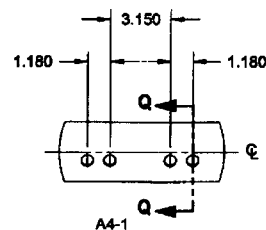
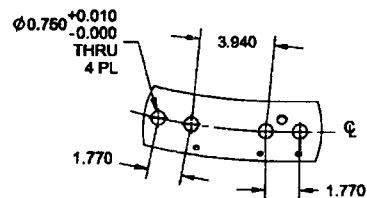
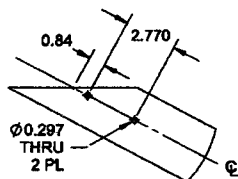
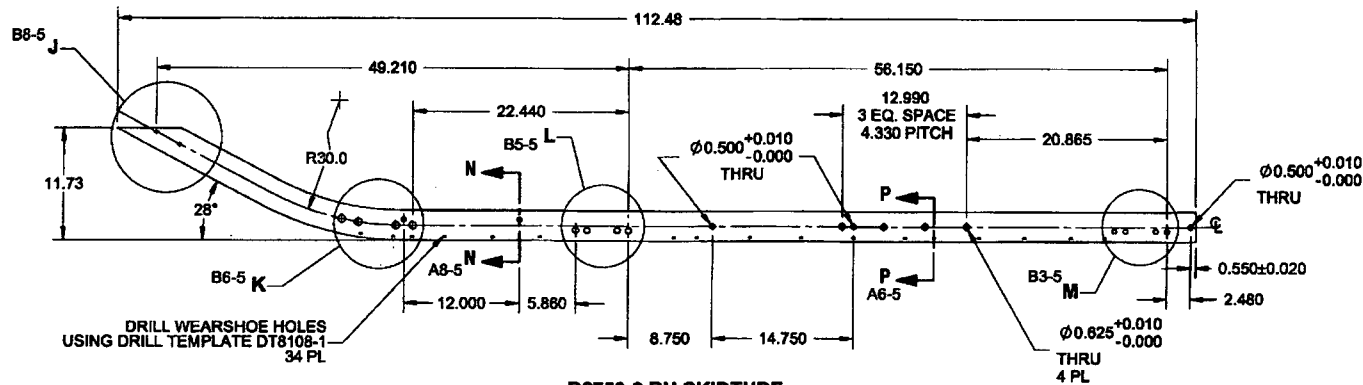
SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL

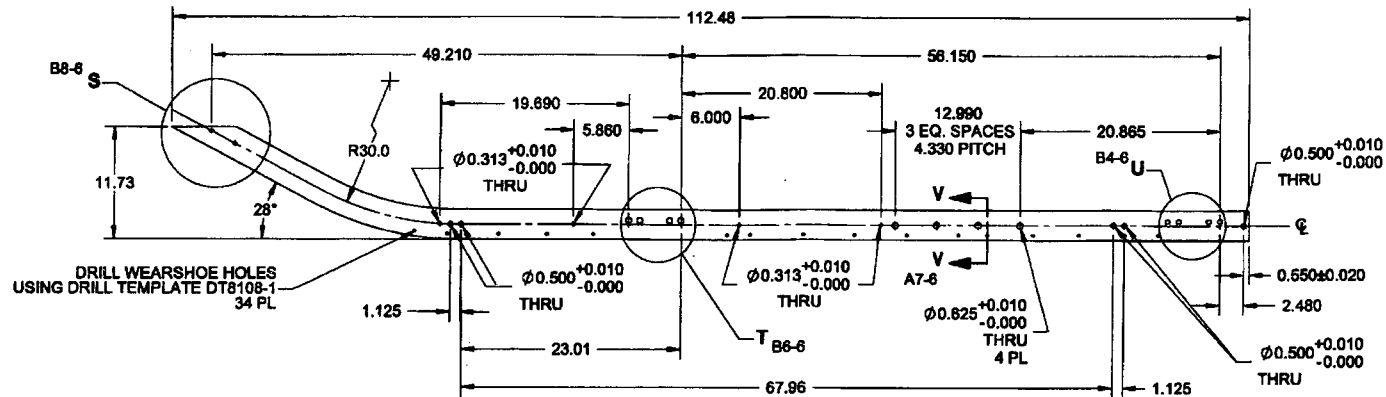
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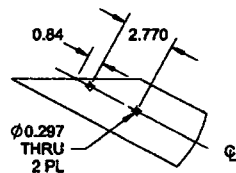


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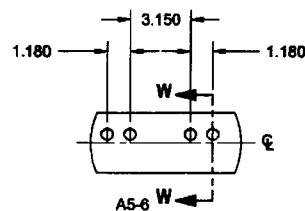
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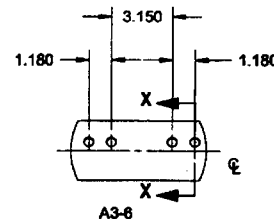
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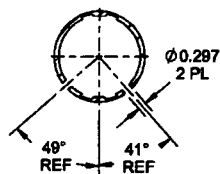
DETAIL S
D8-6
SCALE 2X



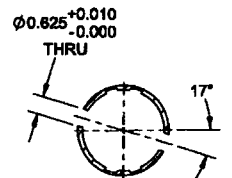
DETAIL T
C5-6
SCALE 2X



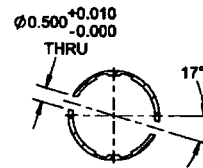
DETAIL U
D3-6
SCALE 2X



SECTION V-V
C4-6
SCALE 3X, 17 PL







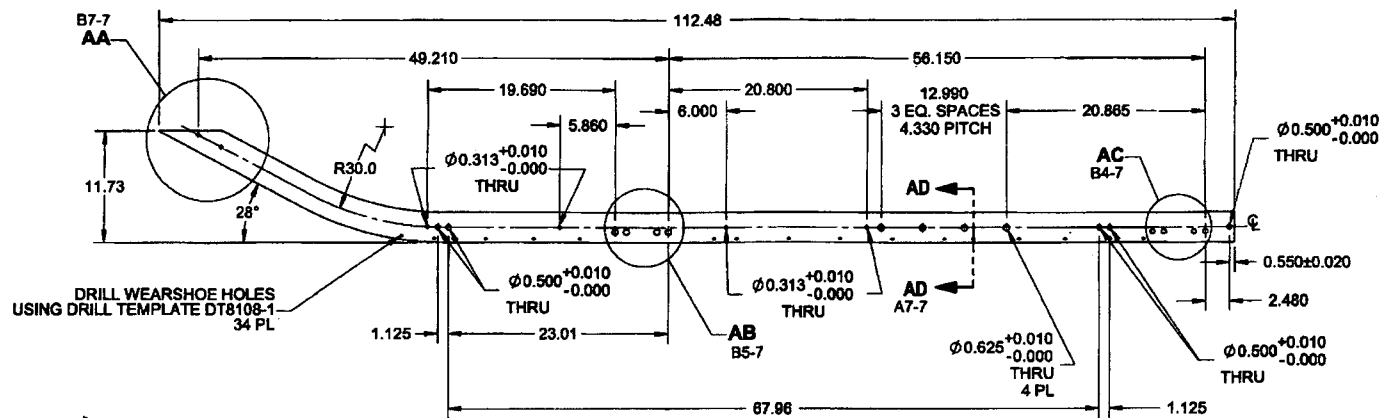
SECTION W-W
B8-6
SCALE 3X, 4 PL



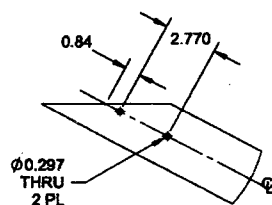
SECTION X-X
B4-6
SCALE 3X, 4 PL

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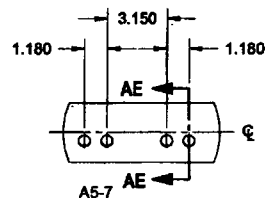
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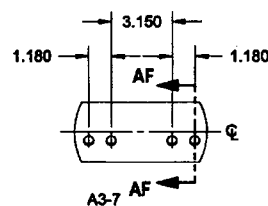
D2750-4 RH SKIDTUBE



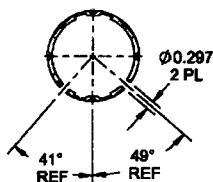
DETAIL AA
D7-7
SCALE 2X



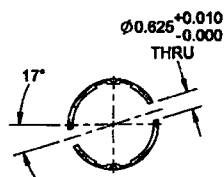
DETAIL AB
C4-7
SCALE 2X



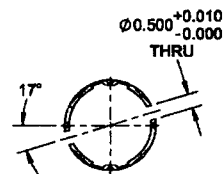
DETAIL AC
D3-7
SCALE 2X



SECTION AD-AD
D3-7
SCALE 3X, 17 PL



SECTION AE-AE
B6-7
SCALE 3X, 4 PL

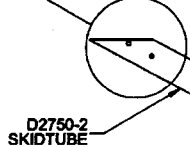


SECTION AF-AF
B4-7
SCALE 3X, 4 PL

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A1-9
AM



D2750-2
SKIDTUBE
AFTER FINISH,
ALS4-1032-225 INSERT
34 PL

BLACK ANTI-SKID

(INSTALL NUT ON THIS SIDE)
REFER TO
SECTION AP-AP

AN8C44A BOLT
D2745 BUSHING
D3631-1 WASHER
SKIDTUBE, REF
D3631-1 WASHER
D2745 BUSHING
MS21043-6 NUT
4 PL

BOND D2739 WEB INTO D2750-2 OUTER TUBE
WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE
PER DART QSI 015.
NOTE: ENSURE THAT HOLES LINE UP.

1.78 TO
D2739 WEB

D3488-042
BLADE FITTING

AN8C35A BOLT
D3793-3 WEARSHOE, REF
D3794-3 GASKET, REF
SKIDTUBE, REF
D3488-042 BLADE FITTING, REF
SKIDTUBE, REF
D3794-3 GASKET, REF
D3793-3 WEARSHOE, REF
AN880C818L WASHER
MS21083C8 NUT
(INSTALL NUT ON THIS SIDE)

AN3C5A BOLT
AN960C10L WASHER
34 PL

D3784-1
GASKET
D3793-1
WEARSHOE

D3537-1
WEARPAD

D3791-1
WEARPLATE

D3536-25
GASKET

D3535-25
WEARSHOE

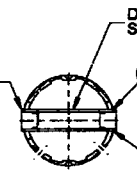
D3537-1
WEARPAD

D3794-3
GASKET
D3793-3
WEARSHOE

D2750-042 350 SKIDTUBE ASSEMBLY, RH

RELEASED
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AFTER FINISH,
INSTALL
D3492-043
PLUG ASSEMBLY
BOTH ENDS



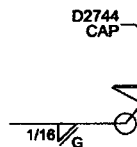
SECTION AN-AN
SCALE 3X, 4 PL

WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D3490-3 SPACER (Ø0.750 HOLES)
3) WELD INTO PLACE, GRIND FLUSH



SECTION AQ-AQ
SCALE 3X, 4 PL

WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D2743 SPACER (Ø0.625 HOLES)
3) WELD INTO PLACE, GRIND FLUSH
4) DRILL OUT SPACER TO Ø0.484



DETAIL AM
SCALE 2X

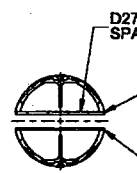
AFTER FINISH,
INSTALL
ALS4-1032-225 INSERT
AN3C6A BOLT
AN960C10L WASHER
NAS1515H3L WASHER
4 PL

AFTER FINISH,
INSTALL
D3492-041
PLUG ASSEMBLY
BOTH ENDS



SECTION AP-AP
SCALE 3X, 4 PL

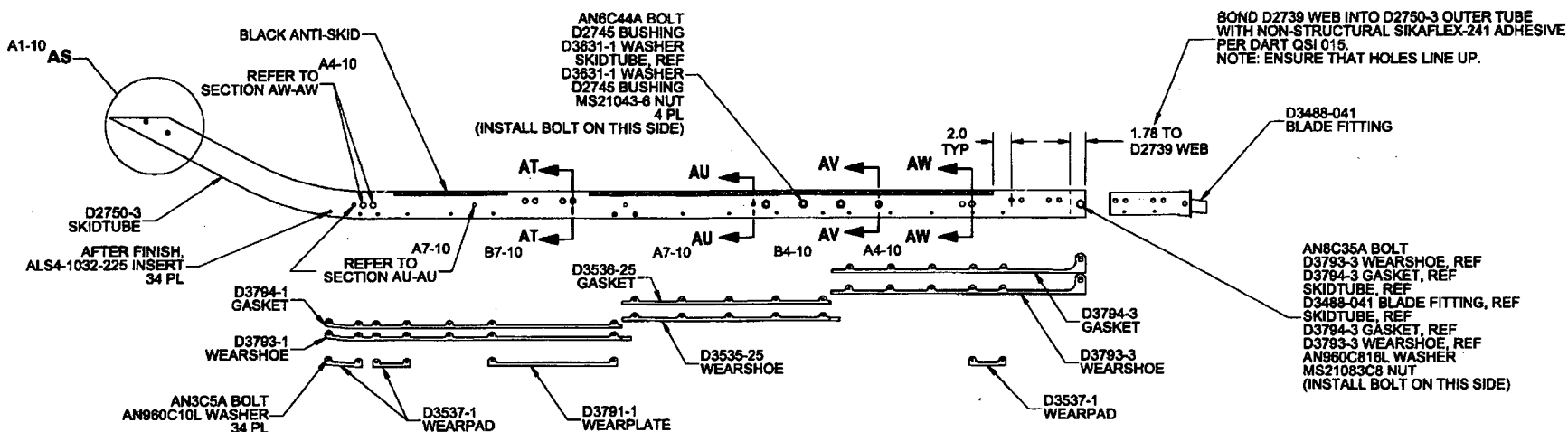
WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D3490-1 SPACER (Ø0.500 HOLES)
3) WELD INTO PLACE, GRIND FLUSH



SECTION AR-AR
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

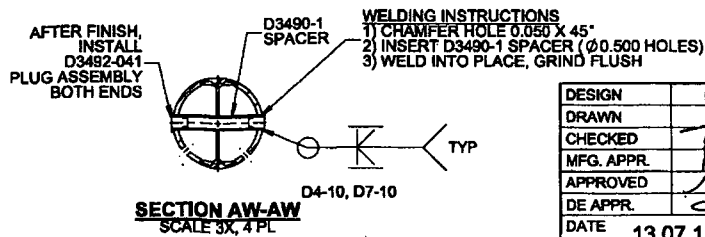
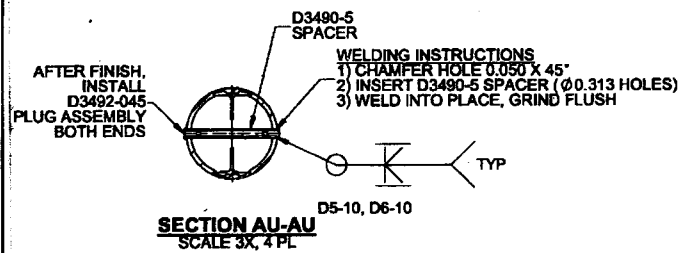
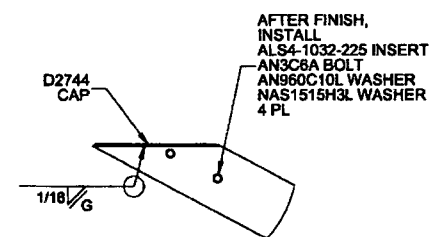
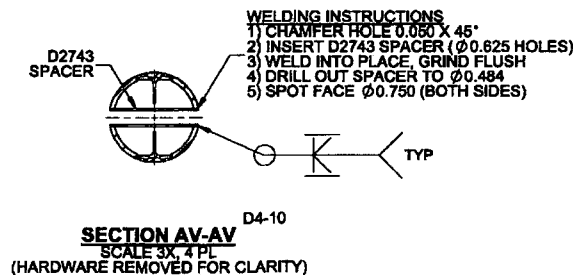
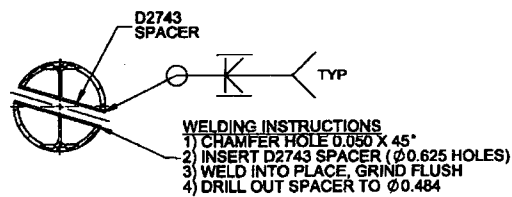
WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D2743 SPACER (Ø0.625 HOLES)
3) WELD INTO PLACE, GRIND FLUSH
4) DRILL OUT SPACER TO Ø0.484
5) SPOT FACE Ø0.750 (BOTH SIDES)

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D2750-043 350 SKIDTUBE ASSEMBLY, LH

RELEASE
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